

AMENDMENTS TO THE CLAIMS

Claims 1-62 (Canceled).

63. (New) A multi-ply web material comprising at least three plies joined to one another by adhesive, wherein:

- a first ply forming a first outer surface of said web material has a first pattern composed of first decorative elements, each of said first decorative elements being formed of at least one protuberance projecting inward of said web material and obtained by embossing said first ply, said first decorative elements having a density of no more than 3 elements/cm²;

- a second ply forming a second outer surface of said web material has a second pattern composed of second decorative elements, each of said second decorative elements being formed of at least one protuberance projecting inward of said web material and obtained by embossing said second ply, said second decorative elements having a density of no more than 3 elements/cm²;

- at least a third ply is interposed between said first ply and said second ply;

– at least a first adhesive is applied in areas corresponding to at least some of the protuberances defining said first decorative elements of the first ply; and

– the first decorative elements and the second decorative elements are different from each other and are distributed randomly with respect to each other.

64. (New) The web material as claimed in claim 63, wherein said first adhesive is applied to the third ply in said areas.

65. (New) The web material as claimed in claim 64, wherein said first adhesive is made to seep at least partly through said third ply and said first ply and reciprocally adheres said third ply to said first ply as well as said third ply to said second ply.

66. (New) The web material as claimed in claim 63, wherein a second adhesive is applied to the second ply at a level of at least some of the protuberances defining said second decorative elements.

67. (New) The web material as claimed in claim 66, wherein said first adhesive reciprocally adheres the first ply and the third ply and said second adhesive reciprocally adheres said third ply and said second ply.

68. (New) The web material as claimed in claim 63, wherein said first ply has a background pattern.

69. (New) The web material as claimed in claim 68, wherein the background pattern of said first ply is composed of protuberances with a geometrical form, of a height less than the protuberances forming said first decorative elements.

70. (New) The web material as claimed in claim 68, wherein said background pattern of the first ply has a density equal to or greater than 8 protuberances/cm².

71. (New) The web material as claimed in claim 63, wherein said second ply has a background pattern.

72. (New) The web material as claimed in claim 71, wherein the background pattern of said second ply is composed of protuberances with a geometrical form, of a height less than the protuberances forming said second decorative elements.

73. (New) The web material as claimed in claim 71, wherein said background pattern of the second ply has a density equal to or greater than 8 protuberances/cm².

74. (New) The web material as claimed in claim 71, wherein said background pattern of the second ply is flattened at a level of the protuberances forming the first decorative elements on said first ply.

75. (New) The web material as claimed in claim 63, wherein at least some of the protuberances defining said

second decorative elements are flattened at a level of respective protuberances defining said first decorative elements.

76. (New) The web material as claimed in claim 63, wherein said third ply is devoid of embossing.

77. (New) The web material as claimed in claim 63, wherein said third ply is colored.

78. (New) The web material as claimed in claim 63, wherein said third ply has a printed pattern.

79. (New) The web material as claimed in claim 63, wherein one or more of said first ply, said second ply and said third ply are composed of two or more layers.

80. (New) The web material as claimed in claim 79, wherein said two or more layers are joined to one another by mechanical ply-bonding.

81. (New) The web material as claimed in claim 79, wherein at least said third ply is composed of two or more layers.

82. (New) The web material as claimed in claim 63, wherein said at least one third ply is adhered to the second ply by lamination at the protuberances forming said second decorative elements.

83. (New) The web material as claimed in claim 63, wherein said first adhesive and said second adhesive are chromatically different from each other.

84. (New) The web material as claimed in claim 63, made up in a roll.

85. (New) The web material as claimed in claim 84, wherein at least the first pattern is composed of decorative elements symmetrical with respect to a straight line parallel to an axis of the roll.

86. (New) Method for producing a multi-ply web material comprising:

- embossing a first ply defining a first outer surface of said web material forming thereon a first pattern composed of first decorative elements, each of said first decorative elements being formed by at least one protuberance projecting inward of said web material, said first decorative element having a density of no more than 3 elements/cm²;

- embossing a second ply defining a second outer surface of said web material forming thereon a pattern composed of second decorative elements, each of said second decorative elements being formed by at least one protuberance projecting inward of said web material, said second decorative elements having a density of no more than

3 elements/cm², the first decorative elements and the second decorative elements differing from each other and being distributed randomly with respect to each other, said first decorative elements and said second decorative elements being distributed randomly with respect to each other;

- providing at least a third ply interposed between said first ply and said second ply;

- applying at least a first adhesive in areas corresponding to at least some of the protuberances defining said first decorative elements.

87. (New) The method according to claim 86, wherein said first ply is embossed in a first embossing unit to form thereon said first pattern and said second ply is embossed in a second embossing unit to form said second pattern, the second ply following embossing being fed from said second embossing unit to said first embossing unit to be joined to said first ply.

88. (New) The method as claimed in claim 86, wherein said first adhesive is applied to the first ply at a level of at least some of the protuberances forming said first decorative elements.

89. (New) The method as claimed in claim 88, wherein the first adhesive is made to seep at least partly between said third ply and said first ply to reciprocally adhere

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said third ply to said first ply as well as said third ply to said second ply.

90. (New) The method as claimed in claim 86, wherein said first adhesive is applied to the first ply at a level of at least some of the protuberances forming said first decorative elements.

91. (New) The method as claimed in claim 86, wherein a second adhesive is applied to the second ply at a level of at least some of the protuberances defining said second decorative elements.

92. (New) The method as claimed in claim 90 or 91, wherein said first adhesive reciprocally adheres the first ply and the third ply and said second adhesive reciprocally adheres said third ply and said second ply.

93. (New) The method as claimed in claim 86, wherein said first ply is embossed between a first pressure roller and a first embossing cylinder having projections corresponding to the protuberances forming said first decorative elements, and said second ply is joined to said first ply laminating said first ply and said second ply between the first embossing cylinder and a first laminating roller, with said at least one third ply interposed between the first ply and the second ply.

94. (New) The method as claimed in claim 93, wherein said first adhesive is applied to at least some of the protuberances produced on said first ply when said first ply is engaged with the first embossing cylinder, and wherein said second ply and said third ply, previously adhered to each other at a level of at least some of the second decorative elements, are placed on the first ply and laminated therewith between the first embossing cylinder and the first laminating roller after application of the first adhesive.

95. (New) The method as claimed in claim 86, wherein said first ply is previously embossed with a background pattern.

96. (New) The method as claimed in claim 95, wherein said background pattern is flattened at a level of said first decorative elements.

97. (New) The method as claimed in claim 86, wherein said second ply is embossed between a second pressure roller and a second embossing cylinder with projections corresponding to the protuberances forming said second decorative elements, and said second ply is joined to said third ply laminating said second ply and said third ply between the second embossing cylinder and a second laminating roller, said second embossing cylinder and said

second laminating roller being disposed upstream of the first embossing cylinder and the first laminating roller.

98. (New) The method as claimed in claim 97, wherein said second adhesive is applied to the protuberances produced on said second ply when the second ply is engaged with the second embossing cylinder, said third ply being placed on the second ply after application of the second adhesive and laminated with the second ply between the second embossing cylinder and the second laminating roller.

99. (New) The method as claimed in claim 97, wherein said second ply is previously embossed with a background pattern.

100. (New) The method as claimed in claim 99, wherein said background pattern on the second ply is flattened at a level of said second decorative elements.

101. (New) The method as claimed in claim 95, wherein the background pattern of said first ply is composed of protuberances with a geometrical form, of a height less than the protuberances forming said second decorative elements.

102. (New) The method as claimed in claim 95, wherein said background pattern of the first ply has a density equal to or greater than 8 protuberances/cm₂.

103. (New) The method as claimed in claim 99, wherein the background pattern of said second ply is composed of

protuberances with a geometrical form, of a height less than the protuberances forming said second decorative elements.

104. (New) The method as claimed in claim 103, wherein said background pattern of the first ply has a density equal to or greater than 8 protuberances/cm².

105. (New) The method as claimed in claim 103, wherein said background pattern of the second ply is flattened at a level of a protuberances forming the first decorative elements on said first ply when the first ply, the second ply and the third ply are joined to one another.

106. (New) The method as claimed in claim 86, wherein said third ply is devoid of embossing.

107. (New) The method as claimed in claim 86, wherein said third ply is printed.

108. (New) The method as claimed in claim 86, wherein one or more of said first ply, said second ply and said third ply are formed of two or more layers.

109. (New) The method as claimed in claim 108, wherein said two or more layers are joined to one another by ply-bonding.

110. (New) The method as claimed in claim 108, wherein at least said third ply is composed of two or more layers.

111. (New) The method as claimed in claim 86, wherein said first adhesive and said second adhesive are chromatically different from each other.

112. (New) The method as claimed in claim 86, wherein said web material is made up in a roll.

113. (New) The method as claimed in claim 112, wherein at least the first pattern is composed of designs symmetrical with respect to a straight line parallel to an axis of the roll.

114. (New) The method as claimed in claim 86, wherein said third ply is colored.

115. (New) The method as claimed in claim 86, wherein said protuberances forming the second decorative elements on the second ply are at least partly flattened at a level of the protuberances forming the first decorative elements.

116. (New) Device for producing embossed multi-ply web material, comprising:

- a first embossing-laminating unit comprising a first embossing cylinder equipped with first projections defining a first pattern for generating first decorative elements on a first ply, a first pressure roller cooperating with said first embossing cylinder, a first laminating roller and a first adhesive dispenser disposed between said first pressure roller and said first laminating roller;

- an embossing unit comprising at least a second embossing cylinder equipped with second projections defining a second pattern for generating second decorative elements on a second ply, and a second pressure roller cooperating with said second embossing cylinder;

- a first path for at least a first ply towards and through said first embossing-laminating unit;

- a second path for at least a second ply towards and through said second embossing unit;

- a third path for said third ply;

- said first embossing unit and said second embossing unit and said first path and said second path for said first ply and said second ply are arranged such that said first decorative elements and said second decorative elements are distributed randomly with respect to each other on said first ply and said second ply.

117. (New) The device as claimed in claim 116, wherein said second embossing unit is a second embossing-laminating unit and comprises: a second laminating roller cooperating with said second embossing cylinder; and a second adhesive dispenser disposed between said second pressure roller and said second laminating roller.

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118. (New) The device as claimed in claim 117, wherein said third path for the third ply extends towards and through said second embossing-laminating unit.

119. (New) The device as claimed in claim 116, comprising along said first path a first secondary embossing unit to produce a background pattern on said first ply.

120. (New) The device as claimed in claim 116, comprising along said second path a second secondary embossing unit to produce a background pattern on said second ply.

121. (New) The device as claimed in claim 116, comprising a printing unit.

122. (New) The device as claimed in claim 121, wherein said printing unit is positioned along said third path.

123. (New) The device as claimed in claim 116, comprising a ply-bonding unit.

124. (New) The device as claimed in claim 123, wherein said ply-bonding unit is disposed along said third path.